

5/43

SPLIT

DART AEROSPACE LTD	Work Order:	24520 A
Description: Wearplate	Part Number:	D3460-3
Dwg: D3460 Rev. A; D2577 Rev. E	Qty:	8 4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	PL	05.10.20	8
2	PG	Issue P/O: <u>2008744</u> Email or Ship DXF file to vendor Laser Cut D2577-101 flat pattern as per Dwg D2577 Material release note required	ML	05.09.20	8
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CL	05/10/20	8
4	QC6	Inspect dimensions per template D2577-101T	SB	05/10/20	8
5	GB	Deburr, if necessary	W/A		
6	GB	Form on brake as per Dwg D2577 using DT8155 and DT8179	SB	05/10/20	8
7	GB	Form end joggle as per Dwg D2577 using DT8157 Identify as D3460-3	SB	05/10/24	8
8	GB	Form Detail "A" joggle of Dwg D3460 using DT8157	SB	05/10/24	8
9	QC5	Inspect work to Step 8	PL	05.11.08	8
10	WS	Weld hard surface using DT8308A & DT8308B as per Dwg D3460 Qty Part Number Description Batch A/R 7560 Hardcoat Rod A17953	CPL	05.11.15	4
11	QC9	Inspect weld	PL	05/11/15	4
12	FP	Powder Coat Grey Sandtex (Ref.4.3.5.6) per QSI 005.4.3	ML	05.11.15	4
13	QC3	Inspect Powder Coat	CL	05/11/16	4
14	ST	Identify and Stock	ML	05.11.16	4
15	AC	Cost / part: <u>18.38</u>	SAC	05.11.21	4
16	DC	Close W/O <u>18.38</u> Inspect Level 21	PL	05/11/22	4

Rev	Date	Change	Revised By	Approved
A	05.10.20	New Issue	KJ/EC	B

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/10/25	7	Step 7 not necessary. No rear toggle remove. permanent change.	N/A			05-10-25	05-10-25

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-25	7	Joggle removed on end of wear plate, that's not needed.	05/11/22	Remove joggle on press brake by re-pressing SB radius using DT 8155 8179.	05/11/22	05-11-08	05-10-25	05-10-25

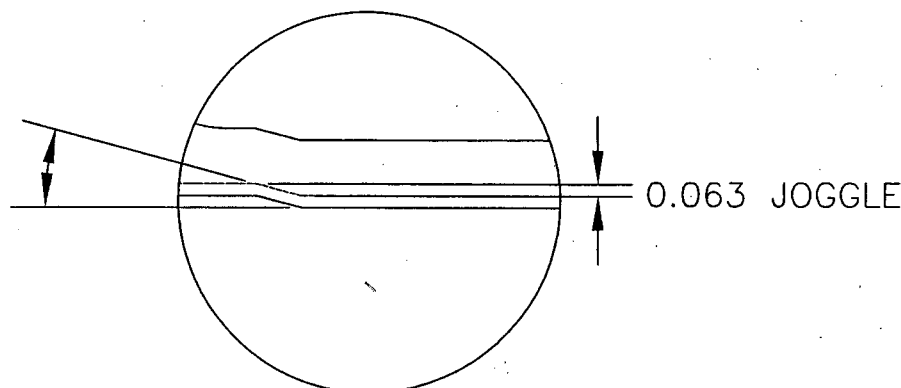
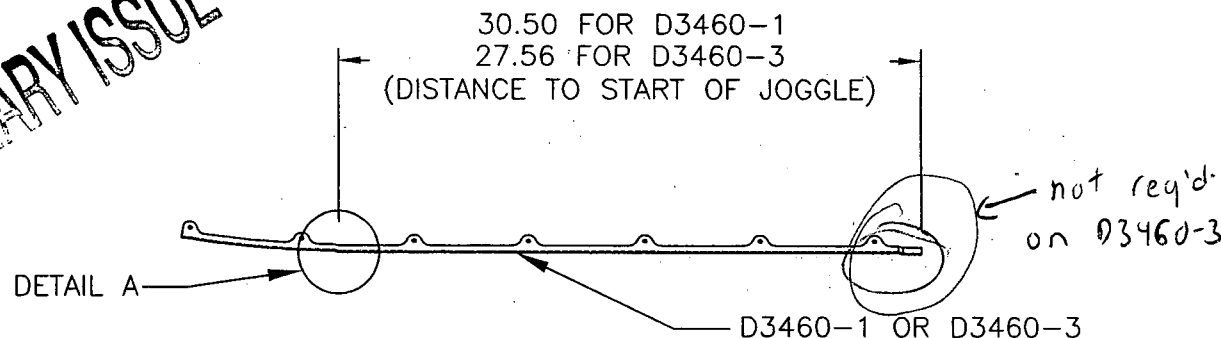
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: ☒ Yes ☐ No DQA: ☒ Date: 05/11/22

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

**PRELIMINARY ISSUE**



DETAIL A  
(SCALE 1:1)

D3460-1/-3 WEARSHOE

- 1) MAKE D3460-1 FROM D2577-11 LONGITUDINAL BEND
- 2) MAKE D3460-3 FROM D2577-13 LONGITUDINAL BEND
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOOT COPY  
RETURN TO  
ENGINEERING  
DEPT. 1  
WITH 100  
ICE  
W/CRK OR DT  
NO. 24530

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3460	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.10.04	WEARSHOE	1:10	
A	05.10.04	NEW ISSUE	

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 11, 2005  
11:50 am

Work Order No : 0024520  
Project Name : D3460-3  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3460-3  
Description :  
Manufactured : No  
Amount Req'd : 0  
Amount Done : 0  
Start Date : 10-11-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Wednesday, 11/16/2005 1:25:00 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPLATE
<b>Job Number</b> : 24520	
<b>Estimate Number</b> : 10621	
<b>P.O. Number</b> :	<b>Part Number</b> : D34603
<b>This Issue</b> : 11/16/2005 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3460 REV. A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/30/2005 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est: A 05.10.20 New Issue KJ/EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

Email or Ship DXF file to vendor

Laser Cut D2577-101 flat pattern as per Dwg D2577

Material release note required

2.0	D2577101F	Wearplate (flat pattern)
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 WEARPLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per inspection template D2577-101T

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Date: Wednesday, 11/16/2005 1:25:00 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 24520

Part Number: D34603

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1- Form on brake using DT8155 and DT8179 as per Dwg D2577 Rev: \_\_\_\_\_

2- Form end joggle using DT8157 as per Dwg D2577

3- Form Detail "A" joggle using DT8157 as per Dwg D3460 Rev: \_\_\_\_\_

Identify as D3460-3

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D3460 Rev: \_\_\_\_\_

Qty	Part Number	Description	Batch
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A/R	N/A	7560 Hardcoat Rod	_____
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9.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**Date:** Wednesday, 11/16/2005 1:25:00 PM  
**User:** Linda Lacelle

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** WEARPLATE

**Job Number:** 24520

**Part Number:** D34603

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

13.0

DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion



*No Dwg to  
ATTACH TO ESTIMATE*

Dart Aerospace Ltd.  
Hawkesbury

# Job Costing Report

Nov 08, 2005  
12:22 pm

Work Order No : 0024520  
Project Name : D3460-3  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3460-3  
Description : Wearplate  
Manufactured : Yes  
Amount Req'd : 8  
Amount Done : 0  
Start Date : 10-11-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	1.12	100.00		
Production Cost	0.00	27.00	100.00	0.00	27.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	27.00	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	27.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	( -27.00)

*M/S 01/03  
11-16*